DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 70.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-003996
Date Inspected: 29-Sep-2008

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Japan Steel Works

OSM Arrival Time: 2300
OSM Departure Time: 700
Location: Muroran, Japan

CWI Name: Makhmud Ashadi

Inspected CWI report:	☐	**Yes**	☑	**No**	☐	**N/A**
Electrode to specification:	☑	**Yes**	☐	**No**	☐	**N/A**
Qualified Welders:	☑	**Yes**	☐	**No**	☐	**N/A**
Approved Drawings:	☑	**Yes**	☐	**No**	☐	**N/A**

CWI Present:	☑	**Yes**	☐	**No**		
Rod Oven in Use:	☐	**Yes**	☐	**No**	☑	**N/A**
Weld Procedures Followed:	☑	**Yes**	☐	**No**	☐	**N/A**
Verified Joint Fit-up:	☑	**Yes**	☐	**No**	☐	**N/A**
Approved WPS:	☑	**Yes**	☐	**No**	☐	**N/A**
Delayed / Cancelled:	☐	**Yes**	☑	**No**	☐	**N/A**

Bridge No: 34-0006
Component: Tower, Deviation and Jacking Saddles

Summary of Items Observed:

On this date OSM Quality Assurance (QA) Representative Daniel L. Reyes was present during the welding of the structural steel components for the Tower Saddles relative to this project. The following was observed:

Fabrication Shop # 4

The QA inspector traveled to the fabrication shop to observe the scheduled work on the West Deviation Saddle identified as W2E1. The worked performed was the welding of temporary attachments of the structural steel grillage to the casting. The temporary attachments were located on the end rib plates identified as 1-4 and 1-17 which were attached to the casting. There were a total of six (6) attachments, three (3) at each end and were placed symmetrically at the end rib plate to the casting connection.

The welding was performed by Japan Steel Works (JSW) personnel Satoru Watanabe ID 08-5189 and Kashiwada Mutuo ID 08-2008. The gas shielded Flux Cored Arc Welding (FCAW-G) process was utilized during the welding of the attachments.

The QA inspector observed, at random intervals, the Intertek Inspection Service (ITS) Quality Control (QC) Inspector Makhmud Ashadi perform the visual inspection and the verification of the welding parameters and the surface temperatures.

Later in the shift the QA inspector observed at the stem plate to casting stem connection that a total of fourteen cracks. The QC inspector was informed by the QA inspector regarding this issue.

The digital photographs on page 2 of this report illustrates the observations of the activities performed on this date.

WELDING INSPECTION REPORT

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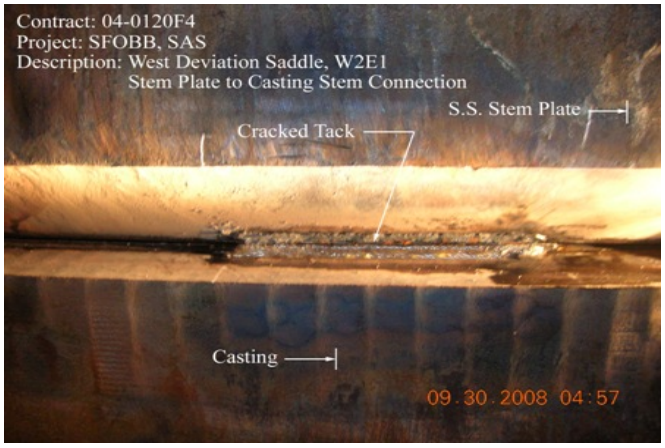

Summary of Conversations:

There were no pertinent conversations relative to the project on this date except as noted.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Venkatesh Iyer, (858) 967-6363, who represents the Office of Structural Materials for your project.

Inspected By:	Reyes,Danny	Quality Assurance Inspector
Reviewed By:	Lanz,Joe	QA Reviewer